

Work Order ID 146204

May 11, 2016 11:55:28 AM

146204

Page 1

Item ID: D4758-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blanking Plate

Start Date: 5/20/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 6/3/2016 Req'd Qty: 30.00

30

Customer:

Reference:

20160511

Approvals:

Process Plan: SA

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4758

A

DAS
07
9-89

100

0.00

100

HandThermo

Memo

1.50

31

16/05/19

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

105

0.00

105

HandThermo

Dry Material

Memo

0.00

31

16/05/19

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: _____

245 deg

Time IN: _____

5:00 PM MAY 16 2016

Time OUT: _____

6:00 AM

Per.....

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

30

Cust Item ID:

30

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stamp

110

0.00

110

6.00

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA152 using tool DT9873

Dwg Rev: A

Folio Rev: A.

Visually inspect for proper formation and texture

140

0.00

140

4.50

HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																							
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May 11, 2016 11:55:28 AM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

30

Cust Item ID:

30

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

Insp. Stamps

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.30

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.60

Quality Control

170

Identify as per dwg & Stock Location: St 23

0.00

170

Packaging

Memo

0.30

Packaging

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 146204

May 11, 2016 11:55:28 AM

146204

Page 4

Item ID: D4758-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blanking Plate
Start Date: 5/20/2016 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 6/3/2016 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	3.00							
Quality Control									

16/5/24/2016

MAY 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐																																																																				
Misidentified ☐	Past Due ☐																																																																				
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																		
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																		
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																		
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																		
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER :																																																																					

Picklist Print

May 11, 2016 11:55:32 AM

Page 1

Work Order ID: 146204

146204

Parent Item: D4758-3

D4758-3

Parent Item Name: Blanking Plate

Start Date: 5/20/2016

Required Date: 6/3/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev. A New Issue 13/01/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	913.3934	1	30			DAS 07 9-89
MI FXS 093-F6006-02									**				
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

therm

913.39337

m127208

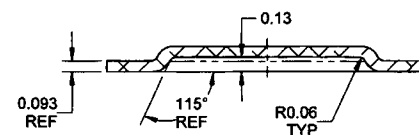
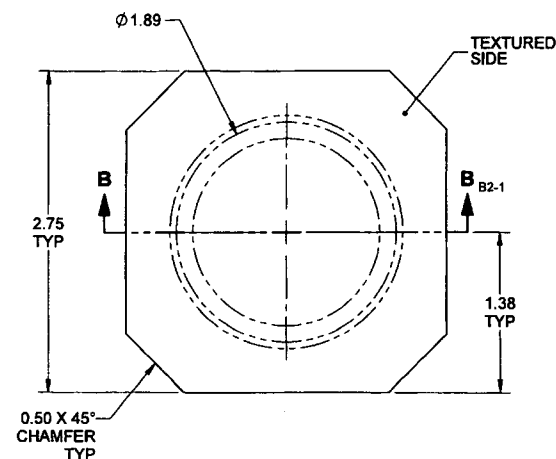
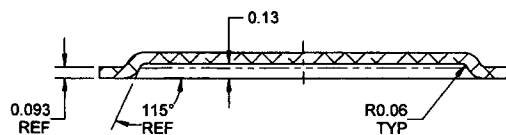
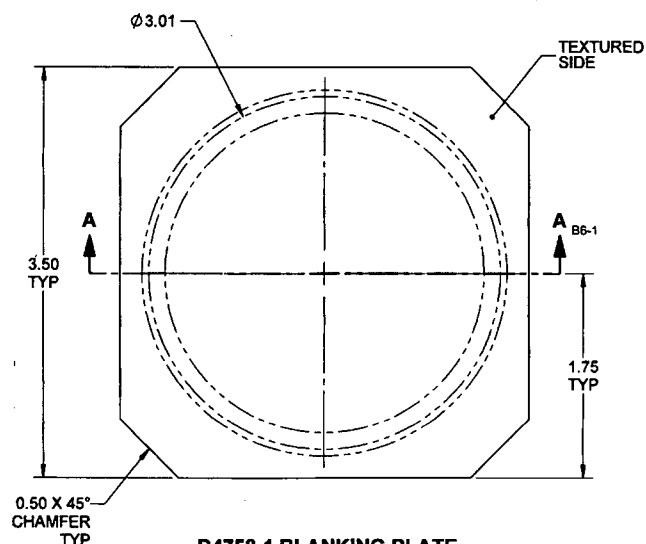
913.39337

29.58 *At*

16/05/19

20160511

146204 SH



NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET, 0.093 THICK
REF. DART SPEC. MLEXS.093-F6006-02
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4758-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
- 7) WEIGHT: D4758-1 = 0.05 lbs; D4758-3 = 0.02 lbs
- 8) TOOLING: - D4758-1: THERMOFORM PER MOLD DT9872 PER QSI 022
- D4758-3: THERMOFORM PER MOLD DT9873 PER QSI 022

RELEASED
2013-01-14

REV.	NEW ISSUE	DESCRIPTION	MB	12.12.07
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.12.07			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4758	SHEET 1 OF 1
TITLE BLANKING PLATES	SCALE NTS

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